

Work Order ID 52968-2

October 20, 2009 7:28:13 AM

Page 1

Item ID: D412-698-012

Revision ID: E

Item Name: Cabin Door Roller, RH

Start Date: 10/20/09 Start Qty: 1.00

Required Date: 10/22/09 Req'd Qty: 3.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr Revision Nbr

IIN D412-698 Rev E

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

36 /

110



Packaging

Packaging

Pick Kit

Memo

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

0.00

0.00

0.00

0.00

Accept



Setup Start

Stop



Cust Item ID:

Customer:

HJ for BG 09/10/20

P 9/10/20 (1) (8)

80 09/10/11

2 8

Work Order ID 52968

October 20, 2009 7:28:14 AM



Page 2

Item ID: D412-698-012
Revision ID: E
Item Name: Cabin Door Roller, RH

Accept



Setup Start



Stop



Start Date: 10/20/09 Start Qty: 3.00
Required Date: 10/22/09 Req'd Qty: 3.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID
130

Operation
Description

Set Up/
Run Hours

Draw Draw Plan Accept Reject Reject Insp.
Number Rev. Code Qty Qty Number Stamp



Packaging
Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-698-012
Location: 60

Rev. B

9/11/12 (2X) SQ

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

09/11/12

MF

09-11-11

Picklist Print

October 20, 2009 7:28:12 AM

Page 1

Work Order ID: 52968

Parent Item: D412-698-012RevE

Parent Item Name: Cabin Door Roller, RH

Comments:

Component Item ID/

Item Name

Replacement
Item ID

Mfg/
Purch

Bin Primary
Item Location

Last
Location

Route
Seq ID

Unit of
Measure

Qty on
Hand

Remaining
Qty To Pick

Qty
Issued

Required Date: 10/22/09

Required Qty: 3.00

Date
Issued

Status

121-141RevE

Manufactured

cket Assembly

Warehouse

Location

Main Warehouse

ST

52465

Loc Qty

Loc Code

11

11

110

Each

11.0000

3.0000



50465 SX

Warehouse

Location

Main Warehouse

ST

45086

52367

Loc Qty

Loc Code

11

5

6

110

Each

29.0000

3.0000



45086

043RevF

Manufactured

Assembly

Warehouse

Location

Main Warehouse

ST

42192

Loc Qty

Loc Code

29

29

42192

PC 5/426 ①

Picklist Print

October 20, 2009 7:28:13 AM

Page 2

Work Order ID: 52968

Parent Item: D412-698-012RevE

Parent Item Name: Cabin Door Roller, RH

Comments:

Start Date: 10/20/09

Required Date: 10/22/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3183-044RevC1		Manufactured	No			110	Each	19.0000	3.0000			
----------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Bracket Assembly

13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

42194

19

110

Each

85.0000

27.0000



D3199-1RevB

Manufactured No



Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

85

47848

2

52466

83

110

Each

32.0000

3.0000



D3202-1RevD

Manufactured No



Cover

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

46253

10

50134

22

46253

9/10/26 (3x) SP

October 20, 2009 7:28:13 AM

Shop Packet Print

Page 2

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
						D3121-144	BRACKET ASSEMBLY
1						D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
						D3183-044	BRACKET ASSEMBLY
9			9			D3199-1	BRACKET
1			1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

52968

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries